

Ship Friday 30

Work Order ID 58052



Page 1

April 22, 2010 11:55:56 AM

Item ID: D4039-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Bracket Assembly

Start Date: 22/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *PP*

Date: 10-4-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4039

A

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble lanyard to bracket as per dwg

Sh 10/04/29

10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Swalows

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

10-4-29 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/30 *[Signature]*
ME
10-4-29

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Picklist Print

April 22, 2010 11:56:01 AM

Page 1

Work Order ID: 58052

Parent Item: D4039-041

Parent Item Name: Fwd Bracket Assembly

Comments: IPP RevA: new issue DD 09.12.15 verified by:EC



Start Date: 22/04/2010



Required Date: 29/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D4039-1		Manufactured	No			100	Each	0.0000	2.0000			
							B57992			SB	10/04/29	(1)
Fwd Bracket												

D2690-6		Manufactured	No			100	Each	7.0000	2.0000			
												
Lanyard Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

7

50665

7

BLRS-010

Purchased

No

100

Each

42.0000

2.0000



Pip Pin

1 SB 10/04/29 (1)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST283

42

112689

22

113779

20

MS27039-1-11

Purchased

No

100

Each

83.0000

2.0000



Screw

1 SB 10/04/29 (1)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST291

83

9662

83

1 SB 10/04/29 (1)

W/O:		WORK ORDER CHANGES					
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Picklist Print

April 22, 2010 11:56:01 AM

Page 2

Work Order ID: 58052



Parent Item: D4039-041



Parent Item Name: Fwd Bracket Assembly

Start Date: 22/04/2010

Required Date: 29/04/2010

Comments: IPP RevA: new issue DD 09.12.15 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 		Purchased	No			100	Each	1,087.000	2.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST300	1087	
113537	103	
113644	984	

NAS1149D0363J



Purchased

No

100

Each

1,630.000

6.0000

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST298	1630	
113288	2	
114292	1628	

SS 10/04/29 ①

SS 10/04/29 ①

April 22, 2010 11:56:01 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

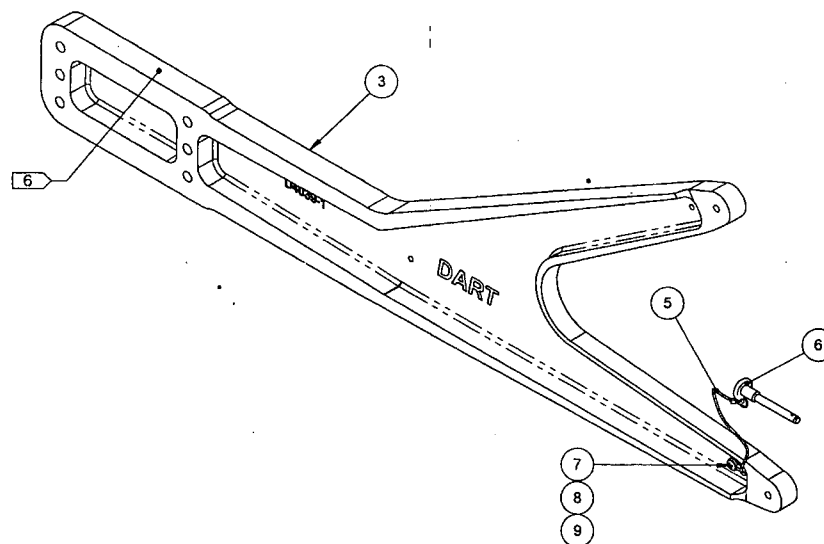
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

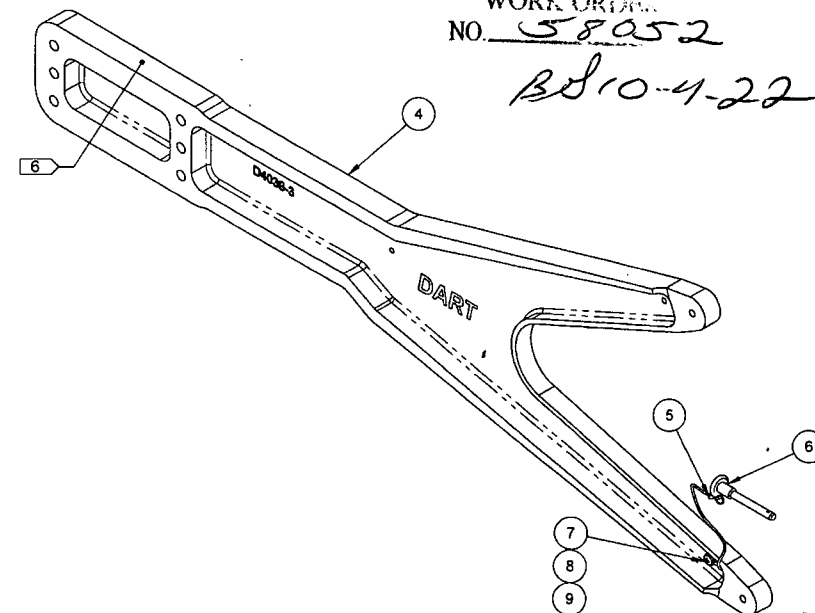
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ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4039-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 58052

B810-4-22

RELEASED
2010-04-14

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.12.14
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039**
TITLE **BRACKET**
REV. A
SHEET 1 OF 3
SCALE
NTS

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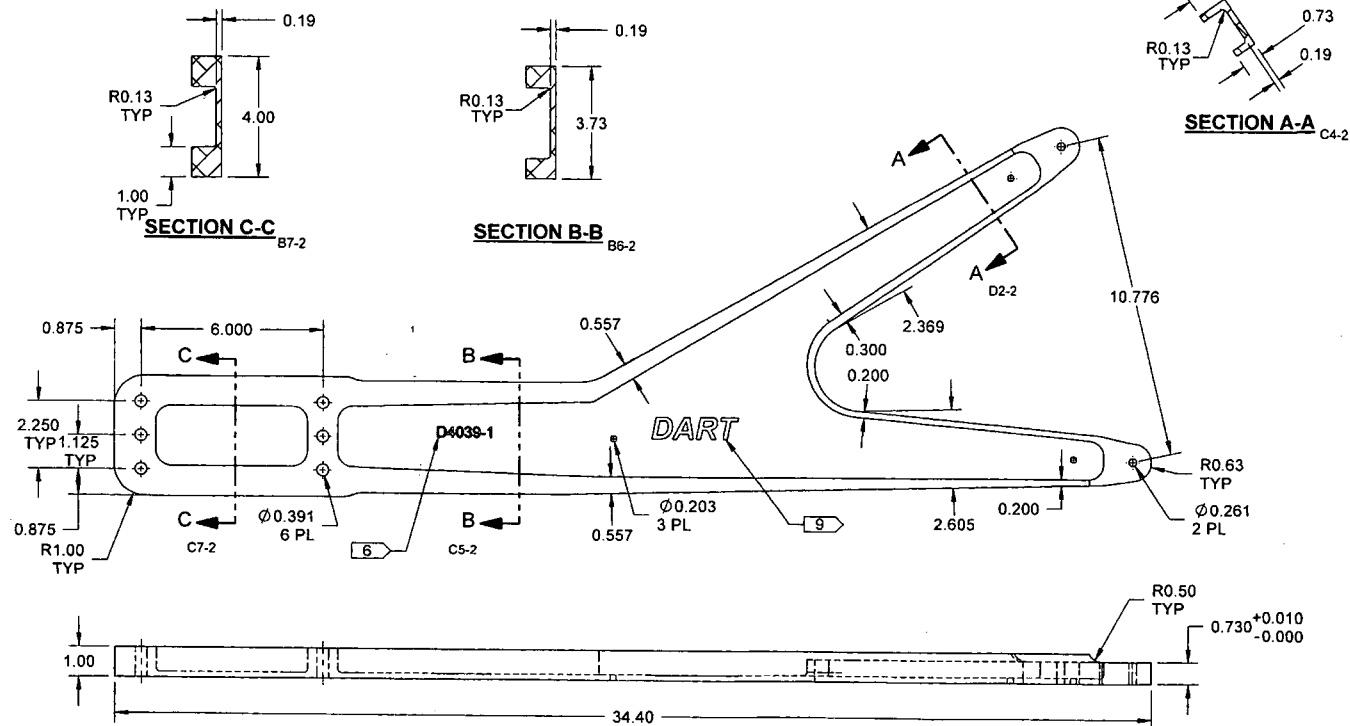
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D4039-1 FWD BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.64 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1.REVA.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

DESIGN	41	DART AEROSPACE LTD	
DRAWN	41	HAWKESBURY, ONTARIO, CANADA	
CHECKED	41	DRAWING NO.	REV. A
MFG. APPR.	41	D4039	SHEET 2 OF 3
APPROVED	41	TITLE	SCALE
DE APPR.	41	BRACKET	NTS
DATE	09.12.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

w/o 58052

RELEASED
R 2010-04-16
NWS

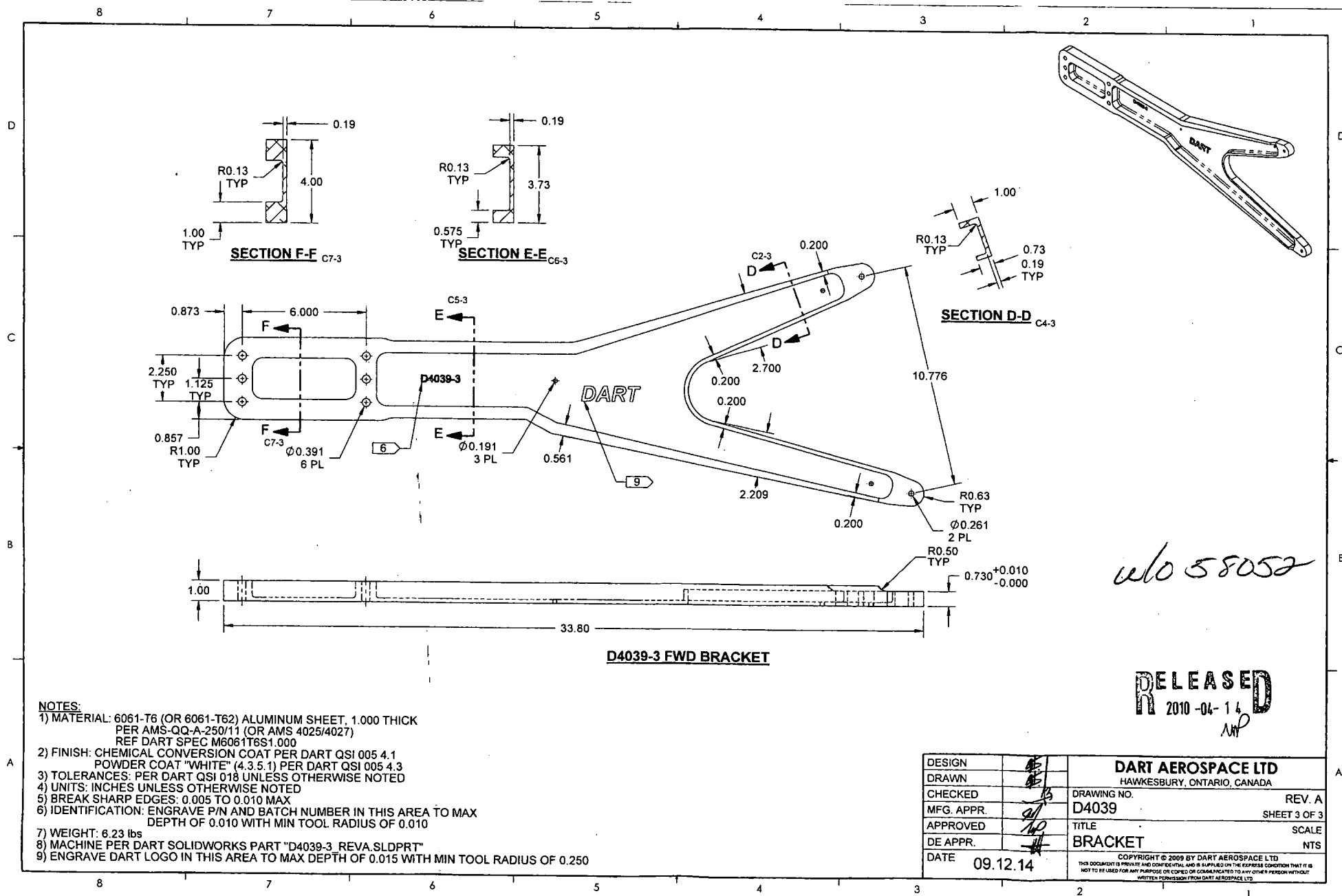
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